



READY High Production Benders - Inch

Our highest production bender - now available up to 36"

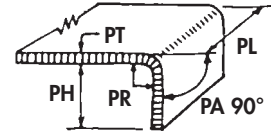
- Use when production exceeds a million parts, ideal for most stamping dies.
- In stock lengths, see page 7. Now available up to 36" long.
- For custom lengths, see page 8.

Features:

- 1. Rockers:** fully hardened (Rc 56 to 62), S-7 tool steel.
- 2. Saddles:** fully hardened, (Rc 48 to 52) A-2 tool steel. Counterbored mounting holes per patterns on pages 7 and 8. Flush mount lube fittings.
- 3.** Rockers and saddles are CNC ground for precision and interchangeability.
- 4.** Rocker angle is 87° on all standard benders. This allows for 3° of overbend to produce consistent 90° forms in mild steel. Harder steel or larger part radii may require more overbend. Rocker angles can be specified at time of order or altered by the diemaker. See page 10 about oversquare bends.

Selecting Standard Benders:

- 1.** Find the PT you are forming in top row of chart below. Read down (vertically) for all data. Verify the PH check (specials can bend shorter PH's).
- 2.** Note minimum and maximum lengths (X) in chart below. Custom lengths are available. Use in stock lengths whenever possible for quick delivery. Longer lengths achieved by butting units end-to-end, .010" gap between.

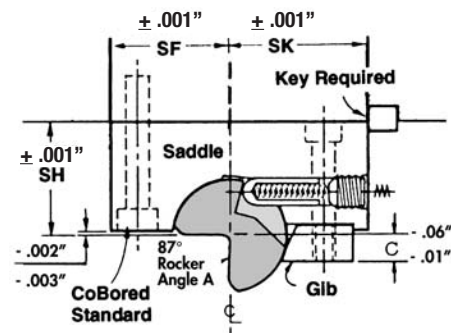


PT = part thickness
PH = part height
PR = part radius
PA = part angle
PL = part length

Standard benders form a 90° bend in mild steel. The PR should roughly equal the PT. If you have questions or need a special quotation, please fax the worksheet on back cover with prints.

| Part Thickness (PT) | .010"-.042" | .043"-075" | .076"-.120" | .121"-.164" | .165"-.209" | .210"-.250" |
|--|----------------------------|--------------------------------------|----------------------------|------------------|------------------|------------------|
| Gage Thickness | 25 to 19 | 19 to 14 | 14 to 11 | 11 to 8 | 8 to 5 | 5 to 1/4" |
| Part Height Check (PH) | .250" | .390" | .580" | .775" | .970" | 1.160" |
| To use standard benders, PH should exceed these dimensions. Fax prints for specials. | | | | | | |
| In Stock Lengths, X = (see page 7) | 1.125" 3.500" 6.000" | 1.500" 4.000" 6.000" 9.000" | 2.000" 5.000" 8.000" | 2.500" 7.000" | 3.000" 7.000" | 3.500" 6.000" |
| Minimum Length (X) (Gib Length - GL) | 1.125" | 1.500" | 2.000" | 2.500" | 3.000" | 3.500" |
| Maximum Length X | 24" | 24" | 36" | 36" | 36" | 36" |
| MODEL CALLOUT | REC 62 | REC 100 | REC 150 | REC 200 | REC 250 | REC 300 |

Standard READY High Production Bender



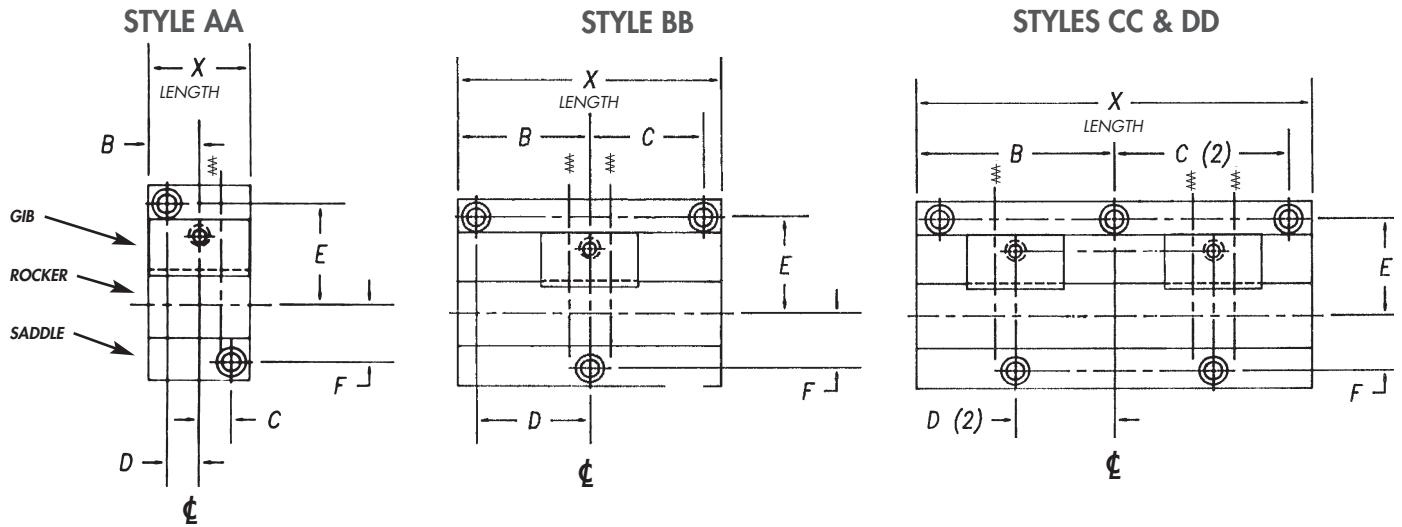
- Tapped mounting holes available as specials.
- For metric mounting holes, see READY High Production Benders, pages 16 to 18.

| Rocker Diameter (87° Angle) | .625" | 1.000" | 1.500" | 2.000" | 2.500" | 3.000" |
|-----------------------------|--------|--------|--------|--------|--------|--------|
| Saddle Width (SW) | 2.125" | 2.875" | 3.875" | 4.875" | 5.875" | 6.875" |
| Saddle to Front (SF) | .750" | 1.125" | 1.500" | 1.875" | 2.250" | 2.750" |
| Saddle to Key (SK) | 1.375" | 1.750" | 2.375" | 3.000" | 3.625" | 4.125" |
| Saddle Height (SH) | .875" | 1.375" | 1.875" | 2.375" | 2.875" | 3.375" |
| Gib Length (GL) | 1.125" | 1.500" | 2.000" | 2.500" | 3.000" | 3.500" |
| Rocker Dimensions | | | | | | |
| (B) | .212" | .339" | .508" | .678" | .848" | 1.017" |
| (C) | .195" | .312" | .468" | .624" | .780" | .936" |
| (J) | .246" | .393" | .590" | .786" | .983" | 1.179" |

READY High Production Benders - Inch: in stock lengths

**READY High
Production Benders** **INCH**

- Our highest production bender.
- Custom lengths up to 24" or 36" long available, see page 8.



Mounting Hole Locations

| Model Callout | Length Style | X Length | B | C | D | E | F | SHCS size |
|---------------|--------------|----------|--------|--------|--------|--------|--------|-----------|
| REC 62 | AA | 1.125" | .562" | .354" | .354" | 1.181" | .551" | #10 |
| | CC | 3.500" | 1.750" | 1.514" | .875" | 1.181" | .551" | #10 |
| | DD | 6.000" | 3.000" | 2.764" | 1.500" | 1.181" | .551" | #10 |
| REC 100 | AA | 1.500" | .750" | .472" | .472" | 1.476" | .846" | 1/4" |
| | BB | 4.000" | 2.000" | 1.724" | 1.724" | 1.476" | .846" | 1/4" |
| | CC | 6.000" | 3.000" | 2.645" | 1.500" | 1.476" | .846" | 1/4" |
| | DD | 9.000" | 4.500" | 4.146" | 2.250" | 1.476" | .846" | 1/4" |
| REC 150 | AA | 2.000" | 1.000" | .669" | .669" | 1.969" | 1.181" | 5/16" |
| | BB | 5.000" | 2.500" | 2.028" | 2.028" | 1.969" | 1.181" | 5/16" |
| | CC | 8.000" | 4.000" | 3.409" | 2.000" | 1.969" | 1.181" | 5/16" |
| REC 200 | AA | 2.500" | 1.250" | .846" | .846" | 2.598" | 1.476" | 3/8" |
| | BB | 7.000" | 3.500" | 2.909" | 2.909" | 2.598" | 1.476" | 3/8" |
| REC 250 | AA | 3.000" | 1.500" | .984" | .984" | 3.110" | 1.732" | 1/2" |
| | BB | 7.000" | 3.500" | 2.791" | 2.791" | 3.110" | 1.732" | 1/2" |
| REC 300 | AA | 3.500" | 1.750" | 1.280" | 1.280" | 3.642" | 2.244" | 1/2" |
| | BB | 6.000" | 3.000" | 2.291" | 2.291" | 3.642" | 2.244" | 1/2" |

Tolerances Held

X = saddle length
+.000"/-.010"

X = rocker length
+.010"/-.000"

Screw locations
held ± .005"

Order Example:

| | | |
|---------------------|--------------------|--------------------------|
| REC | 100 | X = DD |
| READY Model Callout | Rocker Diameter 1" | Specify Length of Bender |

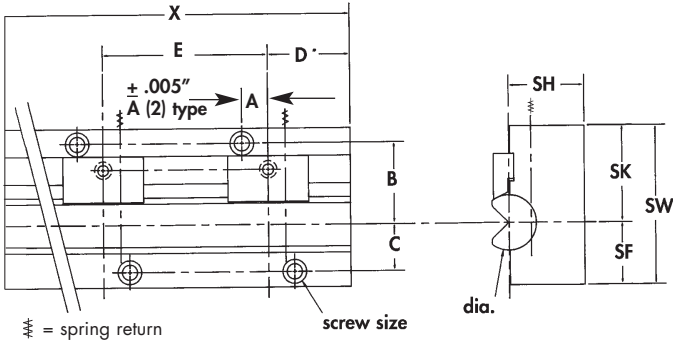


READY High Production Benders - Inch: Custom Lengths

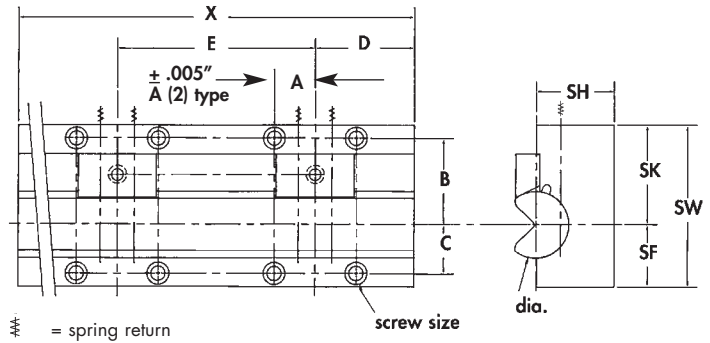
- READY'S CNC grinding technology delivers custom lengths up to 36" long at attractive prices.
- Longer lengths achieved by butting two or more units end-to-end, .010" gap.

- Now available up to 36" long.
- Specify your desired length (X) and READY will deliver.

REC 62, 100 and 150 Repeating Hole Patterns
(for 5/8", 1", and 1 1/2" Diameter Rockers)



REC 200, 250 and 300 Repeating Hole Patterns
(for 2", 2 1/2", and 3" Diameter Rockers)



Minimum/Maximum Lengths:

1. Charts and drawings showing hole locations start at nominal lengths. Custom lengths start very short, at catalog Gib Length (GL) dimensions.
2. Mounting hole patterns for shorter, custom lengths are available upon request by application.

- REC 62** Minimum 1.125" (GL) Maximum 24"
- REC 100** Minimum 1.500" (GL) Maximum 24"
- REC 150** Minimum 2.000" (GL) Maximum 36"
- REC 200** Minimum 2.500" (GL) Maximum 36"
- REC 250** Minimum 3.000" (GL) Maximum 36"
- REC 300** Minimum 3.500" (GL) Maximum 36"

3. Standard in stock lengths of READY High Production Benders are cataloged on page 7. These ship fast and cost less. The READY Bender® - Inch, pages 4 and 5, is available in custom lengths and can further reduce your tooling budget.

NOTE:

- Counterbored holes standard, tapped available as specials.
- READY High Production Bender - metric, pages 16 to 18, is the same product only with metric holes.

| Model and Rocker Diameter | "X" Length | A | B | C | D | E | SHCS size |
|---------------------------|-----------------------|--------|--------|--------|----------|---------|-----------|
| REC 62 5/8" dia. | lengths 6 - 12" | .354" | 1.181" | .551" | "X" ÷ 8 | "X" ÷ 4 | #10 |
| REC 100 1" dia. | | .472" | 1.476" | .846" | "X" ÷ 8 | "X" ÷ 4 | 1/4 |
| REC 150 1 1/2" dia. | | .669" | 1.969" | 1.181" | "X" ÷ 6 | "X" ÷ 3 | 5/16 |
| REC 62 5/8" dia. | lengths 12.5 - 24" | .354" | 1.181" | .551" | "X" ÷ 12 | "X" ÷ 6 | #10 |
| REC 100 1" dia. | | .472" | 1.476" | .846" | "X" ÷ 12 | "X" ÷ 6 | 1/4 |
| REC 150 1 1/2" dia. | | .669" | 1.969" | 1.181" | "X" ÷ 10 | "X" ÷ 5 | 5/16 |
| REC 62 5/8" dia. | lengths 24.5 - 36" | .354" | 1.181" | .551" | "X" ÷ 16 | "X" ÷ 8 | #10 |
| REC 100 1" dia. | | .472" | 1.476" | .846" | "X" ÷ 16 | "X" ÷ 8 | 1/4 |
| REC 150 1 1/2" dia. | | .669" | 1.969" | 1.181" | "X" ÷ 14 | "X" ÷ 7 | 5/16 |
| REC 200 2" dia. | lengths 8 - 12" | 1.240" | 2.598" | 1.476" | | | 3/8 |
| REC 250 2 1/2" dia. | | 1.378" | 3.110" | 1.732" | "X" ÷ 4 | "X" ÷ 2 | 1/2 |
| REC 300 3" dia. | | 1.575" | 3.642" | 2.244" | | | 1/2 |
| REC 200 2" dia. | lengths 12.5 - 24" | 1.240" | 2.598" | 1.476" | | | 3/8 |
| REC 250 2 1/2" dia. | | 1.378" | 3.110" | 1.732" | "X" ÷ 6 | "X" ÷ 3 | 1/2 |
| REC 300 3" dia. | | 1.575" | 3.642" | 2.244" | | | 1/2 |
| REC 200 2" dia. | lengths 24.5 - 36" | 1.240" | 2.598" | 1.476" | | | 3/8 |
| REC 250 2 1/2" dia. | | 1.378" | 3.110" | 1.732" | "X" ÷ 10 | "X" ÷ 5 | 1/2 |
| REC 300 3" dia. | | 1.575" | 3.642" | 2.244" | | | 1/2 |